

RG 104, 8NS-104-94-077
Box 6

8NS-104-94-077, Miscellaneous
Correspondence & Memos, 1897-1994

Notes on Brazilian Currency

Notes on Brazilian Currency

10 - Centavo

Brazil

New Coin.

Dia - .905 -

0.51" = 35.

20 - Centavo

Brazil (new)

Dia .984

Thickness -

.059 1/2 inch

4-17-70

new Upset

new

102 - 1 each

202 - 1 each

Brazil

4-17-70

20 - Centavo

BRAZIL!

Dia = .986

wt = 121.30 gms.

3-27-70

10 - Centavo

Brazil

Dia

.906 - .907

Thickness

0.51 1/2 inch +

BRAZIL-WEIGHTS

10 - CENTAVO = 85.186
GRAINS

20 - CENTAVO = 121.30
GRAINS

10-centavo

Brazil.

Dia = .905

Wt = 85.186 grs.

~~10 centavo~~
~~30 - 9 - 12~~
3/23/70

.05118"

9 : Dia

1 coil

10 Centavo Brazil

73.8 grains rub.

NEW- 20-CENTAVO - BRAZIL 4-17-70
 REC. @ 215 Nix-Alloy
 PASS DIAL GAUGE X-RAY
 1- 235 .190
 ANNEAL
 2- 190 .152
 3- 155 .118
 4- 135 .090
 5- 120 .072 - SELECT 115
 6- 108 .059 1/2 093"
 EDGE = .057 1/2 CENTER = .060 DIA. 984 WT. = 101.08 STD. 0595

NEW- 20-CENTAVO - BRAZIL 1-6-71
 REC. @ 215 REVISED SCHEDULE - LESS AMPS Nix-Alloy
 PASS DIAL GAUGE X-RAY
 1 230 .190
 ANNEAL
 2 220 .170
 3 190 .140
 4 160 .115
 5 135 .090
 6 120 .072 - SELECT - 115
 7 110 .059 1/2 093"
 EDGE = .057+ CENTER = .060 DIA. 984 WT. 101.08 STD. 0595

Blanks only	Annealed and Upset
Country order made for	Brazil 10 Centavos 23 M. M.
Ingots used	2645
Total ozs. in cut Blanks	8,150,561.00 ozs.
Percent recovered	54 %
Blanks recovered per Ingot-oz.	3,122 ozs.
Upset Blank size	.889 "-891"
Upset Blank edge thickness	.060 flat Upset
Cut Blank thickness	.0515
Wt. of cut Blanks	73.77 grains ⁺ 3 grains
Diameter of cut blanks	.903
Date started	February 26, 1971
Date finished	May 3. 1971
Rockwell test B.	40-45
Material	Cupro-Nickel
Total wt. shipped	8,138,332 ozs.
Balance	12,229 ozs.
How shipped	4 bags to box-wt. per bag 803.77 ozs.
	Box size 21" L x 13½" W. x 5½" H measurements
Remarks	No problems

Blanks only	Annealed and Upset
Country order made for	Brazil 20 Centavos 25 M.M.
Ingot's used	3182
Total ozs. in cut Blanks	11,204,285 ozs.
Percent recovered	60%
Blanks recovered per Ingot-oz.	3,521 ozs.
Upset Blank size	.970"-.9685"
Upset Blank edge thickness	.070 Flat Upset
Cut Blank thickness	.0595
Wt. of cut Blanks	101.08 grains standard min. 97.99 gr. max. 104.17 gr.
Diameter of cut blanks	.984
Date started	January 4, 1971
Date finished	June 10, 1971
Rockwell test B.	40-45
Material	Cupro-Nickel
Total wt. shipped	11,152,148 ozs.
Balance	+ Condemns 52,137 ozs.
How shipped	4 bags to box-wt. per bag 803.77 ozs.
	Box-21"Lx13½" W x 5½ h. inside measurements.
Remarks	No problems

Brazil 1970

April 1, 1970

2 Standard Diameters

10-Centavo

20-Centavo

23 MM

25MM

Cut Blank

.905 1/2"

.984"

Upset Blank (max.)

.891"

.970"

(min.)

.889"

.968 1/2"

Max. curvature

.001"

- 0 -

Flat Upset

Thickness of Blank - Min.

.049

Min. .057

St.

.051 *st.*

St.

.059 - *st.*

Max.

.053

Max.

.061

Wt.

Min. 70.06

Min. 97.99

St. 73.77

St. 101.08

Max. 77.47

Max. 104.17

Brazil 1970

204

3/26/70

	<u>Max</u>	<u>Norm</u>	<u>Min</u>
Diam	25.05 mm .9862"		24.95 mm .9823"
Thick	1.55 mm .0610"	1.50 mm .0591"	1.45 mm .0571"
Wt	6.75 grams <small>.1684</small> 104.17 grains .2170 T.oz pcs/T.oz lbs	6.55 grams 101.0819 .2106 4.75 .014440	6.35 grams 97.9955 .2042

1970

BRAZIL

4/17/70

104

204

Pcs	Per bag	Half of order	Half of order
wt	903.77 T.oz	4,051,000 oz	5,562,088 oz

Total 8,138,320 oz Total 11,152,131 oz

Brazil 1970
104

3/26/70

	<u>max</u>	<u>nom</u>	<u>min</u>
Diam - cut	23 mm .9055"		22.9 mm .9015"
Thick	1.35 mm .0531"	1.30 mm .0512"	1.25 mm .0492"
Wt	5.02 grams 77.4704 grains .1614 T.oz	4.78 grams ⁶⁶⁶ 73.77 .1537	4.54 grams 70.062 .1450
	pcs/T.oz lbs	6.51 .010538	

BRAZIL

1970

4/17/70

104

204

Pcs Per bag -
 wt 803.77 T.oz

4,051,000 oz.

5,562,088 oz.

BRAZIL 10 CENTAVOS

Rolling Room finished

1257 Ingots

Ingot wt.	5800 oz.
Total oz. in Cut blanks	4,124,010
oz. recovered from Ingot	3,281 oz.
% of recovery	56.6 %
Upset size size	.889 - .891 dia.
Upset edge thickness	.060 flat upset
Cut blank thickness	.051 \pm .0015
Wt. of Cut Blanks	73.77 \pm 3 grains
Diameter of Cut Blank	.9055

Date started May 14, 1970

Date finished June 8, 1970

Rockwell test 40 - 45

Material Cupro nickel

Total Wt. Shipped 4,067,076 oz.

Balance + Condemns 56,934 oz.

Shipped - 4 bags to box Wt. per bag 803.77 oz.

Box size 21" L x 13 $\frac{1}{2}$ " W x 5 $\frac{1}{2}$ " H (Inside Measurements)

Remarks: No Problems

20 Centavos

Brazil

PASS

DIAL

GAGE

X ray

1

225

.196

ANNEAL

2

185

.147

3

150

.114

4

140

.102

5

125

.082

130

6

115

.071

110 + $\frac{1}{4}$

10 Cartas

Pass	Dial	Gauge	Calibration
1	5	.215-	Calibration 4T
2	235	.190-	4T closed
	anneal		
3	185	.147	
4	✓ 152	.114	
5	132	.090	
6	120	.072	Calif - 115
7	110	.059	" - 93 + 1/4

Edge .058 mm
Center .061 plus

Weight for - 2.2 grains

20 Cartas

Pass	Dial	Gauge	Calibration
1	5	.215-	Calibration 4T from far
2	235	.190-	4T closed
	anneal		
3	185	.147	
4	150	.114	
5	140	.102	
6	125	.082	Calibrate 130
7	115	.071	" 110 + 1/4

Edge .068
Center .072

Weight for - 4 grains

November 1961

GSA FPMR (41 CFR) 101-11.6

MEMORANDUM OF CALL

Date

3/27

Time

TO—

Brazil 10 p

☐ YOU WERE CALLED BY—☐ YOU WERE VISITED BY—

Tentative

TELEPHONE:

Number or code

Extension

☐ PLEASE CALL☐ WAITING TO SEE YOU☐ WILL CALL AGAIN☐ WISHES AN APPOINTMENT☐ RETURNING YOUR CALL☐ IS REFERRED TO YOU BY:

LEFT THIS MESSAGE:

Thick .051^{±2}Draw .905¹/₂ - .901¹/₂Wt 77.5_{max} 73.8

70.1 min

Received By—

20 Centavon

1 225 - 196
anneal

2 - 147 156 .148

126 .118

3 - 114

104 .096

4 .092

.087 .081

5 .075

.071 .071 ^{std}

6 - .064 $\frac{1}{2}$

Edge .0685

Center .0725

X-ray
110

25 ^{std}

10 Centavon

1-225 .196

anneal

2 - 147

148

3 - 114

118

4 - .092

.096

5 - .075

.081

6 - .064 $\frac{1}{2}$

.069

7

.059 ^{std}

Edge .058

Center .061

X-ray
93

Coiner

Material

2 Blanks from Brazil Ingot

Brought to Assay by:
Mr. Mark Burkgren
11/18/69

Date _____

11-28-69

19

Cracked edges - also piece breaking off coil. - Cans pulling back.

Assayer

New April 1 - 1970

Brazil - 20 Centavos

Started 4-15-70 Finished 5-13-70

Weight 101.08 ^{tor - .003} _{grain} Thickness .0595 Standard

Diameter .984 ^{tor - .002}

Ingot used = 1526 ~~Coils~~

Scraped = 10 Coils + Ingot

Total finished
and punched = 1516 ~~Coils~~

Total ounces Finished = 5,610,206 oz's

Brazil 10 Centavos

Started 5-14-70 Finished 6-8-70

Weight 73.77 ^{tor - 3 1/2 grain} _{grain} Thickness

Diameter .9055 ^{tor - .02}

Ingot used = 1268

Scraped = 12 Coils + Ingot

Total finished
and punched = 1257 Coils

4,124,010

Total ounces Finished = ~~4,116,120~~ oz's

New Contract 11/8/68

M/E R Making & Melting

<u>Dept.</u>	<u>Charge</u>
7700	7796 Centavo Ingot
7700	7795 Handling Ingot

Rolling & Blanking

<u>Dept.</u>	<u>Charge</u>
8200	7797 R 10 Centavo-Rolling, Slab Annealing, etc 82
8200	7798 R 20 Centavo-Rolling, Slab Annealing, etc 82
8200	7797 B 10 Centavo - Blanking 82
8200	7798 B 20 Centavo - Blanking 82

Annealing & Chancing

<u>Dept.</u>	<u>Charge</u>
8300	7797 10 Centavo
8300	7798 20 Centavo

UNITED STATES GOVERNMENT

Memorandum

*one part coin from
each end for assay.*

*Rolling & Cutting
Notebook
Accounting*

TO : M&R, Coining, Mechanical and Assay Divisions DATE: 2/29/68

FROM : Cost Accounting Section

SUBJECT: Brazil - Centavo Ingots - melting and processing to blanks - Job Numbers

Dept.

7700

Make-Up & Melting

Charge

7784 - Handling Cupro-Nickel scrap from S.F.A.O.

7785 - Centavo Ingot Make-Up & Melting

Dept.

8100

Process Weighing

8186 - Ten Centavo

8187 - Twenty Centavo

Dept.

8200

Rolling and Blanking

8286-R - Ten Centavo - Rolling, Slab Annealing,
Edge Trimming & Cutting *Rolling*

8287-R - Twenty Centavo - Rolling, Slab Annealing,
Edge Trimming & Cutting *Rolling*

8286-B Ten Centavo Blanking

8287-B Twenty Centavo Blanking

Dept.

8300

Annealing and Cleaning Blanks

Charge

8386 - Ten Centavo

8387 - Twenty Centavo

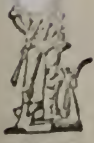
Dept.

8500

Upsetting

8586 - Ten Centavo

8587 - Twenty Centavo



Memorandum (Continued)

Subject: Brazil - Centavo Ingots - melting and processing to blanks -
Job Numbers

Dept.

8400 Automatic Weighing

8486 - Ten Centavo
8487 - Twnety Centavo

Dept.

8800 Selecting

8886 - Ten Centavo
8887 - Twenty Centavo

Dept.

8700 Counting

8786 - Ten Centavo
8787 - Twenty Centavo

Dept.

8900 Miscellaneous Charges & Credits - Preparation for Shipment
8900 - Supervision
8901 - Indirect
8986 - (Ten Centavo - Bagging Blanks & Weighing)
8987 - (Twenty Centavo - Bagging Blanks & Weighing)

8986-2 - Ten Centavo Boxing Bags & Banding Boxes
8987-2 - Twenty Centavo Boxing Bags & Banding Boxes
8985-3 - Purchase or Fabricating of Boxes

Dept.

3500 Assay

7785 Assaying Ingots

6000 Mechanical
Charge

8286-4 - Ten Centavo Die Sets
8287-7 - Twenty Centavo Die Sets

Bill

Office Memorandum • UNITED STATES GOVERNMENT

TO : *Harry Lawrence, Supt. of Mining* DATE: *12-6-67*

FROM : *John J. Collins*

SUBJECT: *Brazilian Ten or Twenty Centavo Rolling,
Slab Annealing, Slitting, etc. - Ingot -
Job Numbers*

Rolling & Blanking Dept Slitting

Dept

\$200

\$200

Job Charge

\$286-R Ten Centavo

\$287-R Twenty Centavo

nl psetting

Dept

Charge

8500

8597

10 Centavo

8500

8598

20 centavo

Selecting

Dept

Charge

8800

8597

10 Centavo

8800

8598

20 Centavo

Automated Weigh

Dept

8400

8497

10 Centavo

8400

8498

20 Centavo

Counting

Dept

8700

Charge

9800 Supervision

9801 Indirect Labor

9897 - 10 Centavo Bags

9898 20 Centavo Bags

9895 - 10 Centavo - Bagging & Weighing

9896 20 Centavo

9899 Purchase of Fabricating Boxes

UNITED STATES GOVERNMENT

Memorandum

Rolling & Blanking

TO : Superintendents-M&R, Coining, Mechanical,
and Assay Divisions

FROM : Cost Accounting Section

SUBJECT: Job Numbers for Second Order-Brazil Centavos

DATE: November 13, 1968

M&R MAKEUP & MELTING

<u>DEPT.</u>	<u>CHARGE</u>	
7700	7796	Centavo Ingot
7700	7795	Handling Ingot

ROLLING & BLANKING

<u>DEPT.</u>	<u>CHARGE</u>	
8200	8297R	10 Centavo - Rolling, Slab Annealing, etc...
8200	8298R	20 Centavo - Rolling, slab Annealing, etc...
8200	8297B	10 Centavo - Blanking
8200	8298B	20 Centavo - Blanking

ANNEALING & CLEANING

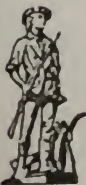
<u>DEPT.</u>	<u>CHARGE</u>	
8300	8397	10 Centavo
8300	8398	20 Centavo

UPSETTING

<u>DEPT.</u>	<u>CHARGE</u>	
8500	8597	10 Centavo
8500	8598	20 Centavo

SELECTING

<u>DEPT.</u>	<u>CHARGE</u>	
8800	8897	10 Centavo
8800	8898	20 Centavo



30 Centoson

Keef 25MM diameter .98425
1.5MM thickness (.059055 (which is thinner))

9-5-69

50 5 centoson

27MM diameter 1.063 $\pm .004$
1.5MM thick .059 $\pm .002$

They want to know what tolerance for oba
2 dimensions. Also, the max. min and
nominal weight. Also max hardness,
Rockwell "B"

Rolling & Cutting

UNITED STATES GOVERNMENT

Memorandum

TO : Superintendents M&R, Coining, and Mechanical
Divisions and Acting Assayer

DATE: October 17, 1969

FROM : Cost Accounting

SUBJECT: Job Numbers for Brazil Centavos, Ingots and Blanks (Replacement of Damaged
Blanks in First Order)

M&R, Makeup and Melting

<u>Dept</u>	<u>Charge</u>	
7700	7793	Centavo Ingots
7700	7794	Handling

Process Weighing

<u>Dept</u>	<u>Charge</u>	
8100	8195	10 Centavo
8100	8196	20 Centavo

Rolling

<u>Dept</u>	<u>Charge</u>	
8200 7900	795R	10 Centavo-Rolling, Slab Annealing, etc.
8200 7900	7996R	20 Centavo-Rolling, Slab Annealing, etc.
	82	

Blanking

<u>Dept</u>	<u>Charge</u>	
8200	8295B	10 Centavo-Blanking
8200	8296B	20 Centavo-Blanking

Annealing and Cleaning

<u>Dept</u>	<u>Charge</u>	
8300	8395	10 Centavo
8300	8396	20 Centavo

Upsetting

<u>Dept</u>	<u>Charge</u>	
8500	8595	10 Centavo
8500	8596	20 Centavo



Brazil

75-25 Cifra Ni

851750

U.S. Units

10/17/61

	10 Centavo			20 Centavo		
	inches Diam	inches Thick	grains Wt	inches Diam	inches Thick	grains Wt
<u>One Disk</u>						
Max	0.90551	0.06103	87.8101	0.98622	0.07284	125.0021
Diff		+0.00197	+2.6235		+0.00197	+3.7038
Std		✓ 0.05906	85.1866	✓ 0.07087	.071	121.2983
Diff		-0.00197	-2.6235		-0.00197	-3.7038
Min	0.90157	0.05709	82.5631	0.98228	0.06890	117.5945
<u>Control Gauge</u>						
Max	0.90748	—	—	0.98819	—	—
Min	0.89960 .00728 ± .00394	—	—	0.98031 .00728 ± .00394	—	—
<u>100 Disks</u>						
Max	—	—	8,642.1216	—	—	12,315.0233
Diff	—	—	+123.4589	—	—	+185.1884
Std	—	—	8,518.6627	—	—	12,129.8349
Diff	—	—	-123.4589	—	—	-185.1883
Min	—	—	8,395.2038	—	—	11,944.6466
Hardness	52 Rockwell "B"			Same as 10 Centavo		
Box of bags	55.15 pounds			"		
Lot of boxes	1,102.31 pounds			"		
Lot numbers	001 — up			500 — up		

UNITED STATES GOVERNMENT

Memorandum

TO : Superintendents of Melting, Coining, Assay and Mechanical Divisions

DATE: December 22, 1970

FROM : Cost Accounting Branch

SUBJECT: Job Numbers for Brazil Centavos Ingots and Blanks (Fourth Order) 600 Metric Ton

<u>Operations</u>	<u>Dept.</u>	<u>Charge</u>	<u>Denominations</u>
<u>Melting:</u>	7700	7770	Ingot
<u>Process Weighing:</u>	8100	8170 8171	10 Centavo 20 Centavo
✓ <u>Rolling:</u> (Includes Slab) Annealing	7900	7970 7971	10 Centavo 20 Centavo
✓ <u>Blanking:</u>	8200	8270 8271	10 Centavo 20 Centavo
<u>Annealing:</u>	8300	8370 8371	10 Centavo 20 Centavo
<u>Upsetting:</u>	8500	8570 8571	10 Centavo 20 Centavo
<u>Selecting:</u>	8800	8870 8871	10 Centavo 20 Centavo
<u>Counting:</u>	8700	8770 8771	10 Centavo, Bagging, Weighing 20 Centavo, Bagging, Weighing
Stores Items		8770	10 Centavo Bags
" "		8771	20 Centavo Bags
" "		8772	10 Centavo Boxes
" "		8773	20 Centavo Boxes
" "		8774	10 Centavo, Boxing Bags, Banding Boxes
" "		8775	20 Centavo, Boxing Bags, Banding Boxes
" "		8776	10 Centavo Skids
" "		8777	20 Centavo Skids



010

10-CENTAVO - BRAZIL.

Rec. Q. 245

NIT-DIEY

PASS DIM L GRUCE X-RAY

1 - 5 .215

2 - 235 .190

ANNEAL.

3 - 185 .147

4 - 150 .114

5 - 130 .090

6 - 120 .072 - SELECT 115

7 - 110 .059 93⁺1/2

EDGE = .057

CENTER = .060

DIA. = .905

WT = 85.186

10 Centavos

.0610 max .0614

.0570 min .0579

20 Centavos

.0728 max .0736

.0689 min .0694

Rolling

UNITED STATES GOVERNMENT

Memorandum

TO : Superintendents of Melting, Coining, Assay,
Mechanical Divisions

DATE: April 2, 1970

FROM : Cost Accounting

SUBJECT: Job Numbers for Brazil Centavos, Ingots and Blanks (Third Order) 300
Metric Tons

Melting

<u>Dept.</u>	<u>Charge</u>	
7700	7751	Centavo Ingots
	7755	Handling Ingots

Process Weighing

<u>Dept.</u>	<u>Charge</u>	
8100	8151	10 Centavo
8100	8152	20 Centavo

Rolling

<u>Dept.</u>	<u>Charge</u>	
7900	8151 7951	10 Centavo Rolling, Slab Annealing, etc
7900	8152 7952	20 Centavo Rolling, Slab Annealing, etc

Blanking

<u>Dept.</u>	<u>Charge</u>	
8200	8251	10 Centavo
8200	8252	20 Centavo

Annealing and Cleaning

<u>Dept.</u>	<u>Charge</u>	
8300	8351	10 Centavo
8300	8352	20 Centavo

Upsetting

<u>Dept.</u>	<u>Charge</u>	
8500	8551	10 Centavo
8500	8552	20 Centavo



Memorandum - Continued

Subject: Job Numbers for Brazil Centavos, Ingots and Blanks (Third Order) 300 Metric Tons

Selecting

<u>Dept.</u>	<u>Charge</u>	
8800	8851	10 Centavo
8800	8852	20 Centavo

Counting

	<u>Dept.</u>	<u>Charge</u>	
	8700	8700	Supervision
		8701	Indirect Labor
		8751	10 Centavo, Bagging, Weighing
		8752	20 Centavo, Bagging, Weighing
Stores Items		8751	10 Centavo Bags
" "		8752	20 Centavo Bags
" "		8753	10 Centavo Boxes
" "		8754	20 Centavo Boxes
		8756	Boxing Bags, Banding Boxes - 10 Centavo
		8757	Boxing Bags, Banding Boxes - 10 Centavo

Assay

<u>Dept.</u>	<u>Charge</u>	
3500	7751	Centavo Ingot

Material Handling - Shipping

<u>Dept.</u>	<u>Charge</u>	
7700	7755	Handling Ingots
7800	8251	Scrap Handling 10 Centavo
	8252	" " 20 "
8700	8756	Preparation of Shipment Cost - 10 Centavo
8700	8757	Preparation of Shipment Cost - 20 Centavo

Mechanical Division

<u>Dept.</u>	<u>Charge</u>	<u>Job Request</u>
6000	8251	#6129 10 Centavo Puncher
	8251	#6130 10 Centavo Thimbles
	8251	10 Centavo Changing & Sharpening Die Sets

Memorandum - Continued

Subject: Job Numbers for Brazil Centavos, Ingots and Blanks (Third Order) 300
Metric Tons

Mechanical Division - Continued

<u>Dept.</u>	<u>Charge</u>	
6000	8252	20 Centavo Changing & Sharpening Die Sets
	8551	Segments, etc.
	8552	" "

OLD

20-CENTAVO-BRAZIL

Ref. C-245

Nix-Alloy

PASS	DIAL.	GRUGE	X-RAY
1-	5	.215	
2-	235	.190	
		ANNEAL	
3-	185	.147	
4-	150	.114	
5-	140	.102	
6-	125	.082 - SELECT-	130
7-	115	.071	110 +1

EDGE = .067 CENTER = .071 DIA = .985 WT = 121.30

1-20-70

600 Metric Ton Brazil

20 Centavo 11.152.131 Troy oz.

10 Centavo 8.138.320 Troy oz.

6.435,000 oz. 20's before
starting 10's. = 1,740 Ingots

NEW 10-CENTAVO - BRAZIL. 1-6-71
 REC. @ .215 REVISED SCHEDULE - LESS AMPS Nix-Alloy
 PASS DIAL GAUGE X-RAY
 1 230 .190
 ANNEAL
 2 215 .165
 3 190 .135
 4 155 .110
 5 135 .090
 6 125 .070
 7 120 .060 - SELECT - 9.8
 8 105 .051 1/2 - 0.78
 EDGE-.049 CENTER-.052 DIA..903 WT-73.77grs STD-.0515

Duplicate 10-CENTAVO - BRAZIL
 NEW 5-28-70
 REC. @ .215 Nix-Alloy
 PASS DIAL GAUGE X-RAY
 1 235 .190
 ANNEAL
 2 190 .152
 3 155 .118
 4 135 .090
 5 120 .072
 6 110 .064 SELECT 100
 7 98 .051 1/2 0.78
 EDGE-.049 CENTER-.052 DIA..903 WT-73.77grs ST-.0515

Notes on Brazilian Currency

Ac 0 47 - 15442
1015 15 10000

